	er <b>ID 67587</b> 28, 2011 11:41:47 A1	М								-		Page 1
Revision ID: Item Name:		<b>Qty:</b> 12.00 <b>Qty:</b> 12.00			Cust Item Customer:	ID:			Setup	Start Stop		
Approvals:	Process Plan:	H	Date;//03-2-8	Tooling: SPC (Y/N):		Pate:		I	Run	Start Stop		
Sequence ID/ Work Center ID	Operat Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nb							,	<del>(</del>			
D3189	Rev B											
Shear	SHEAR	<b>Memo</b> Cut to size a	as per Dwg D3189	0.00	as illos	<b>2</b> 9		(12)	) <u>-</u>			
110 Small Fab Small Fab	Small Fa	Memo 1-Deburr &	Grind Rads as per Dwg D31 r Dwg D3189	0.00 0.00 89	Sn 10	1 03la	9	12	)			
120 	QC5- Ins	pect part compl	leteness to step on W/O	0.00 Sul	<i>जो</i> २५			(HZ	)			

Quality Control

<b>Dart Aerospace L</b>	_td
-------------------------	-----

W/O:		W	ORK ORDER	CHANGES				
DATE	STEP	PROCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		DAP #: Fault Cate			No DO		Date	

						, , ,	<u> </u>	
Part No: _		PAR #:	Fault Category	y:	NCR: Yes No	DQA:	_ Date:	
	Resolution:		Disposition:		QA: N/C Clos	ed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto		
			,							

### Work Order ID 67587

Monday, March 28, 2011 11:41:47 AM



Page 2

Item ID:

D3189-1

Accept

Setup Start

Item Name: **Start Date:** 

Required Date: 3/31/2011

**Revision ID:** 

3/28/2011

Chafing Shield

**Start Oty: 12.00** 

Req'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

**Tooling:** 

Date:

Run

Start

Stop



Date:\_\_\_\_\_

Identify as per dwg & Stock Location: X tule 0.00

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Accept

Reject Qty

Reject Insp.

**Work Center ID** 

130

Sequence ID/

Packaging Packaging

Operation

Description

Memo

**Tool ID** 

Tool # Plan Code

Qty

Stop

Number Stamp

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/30cpc) NWF 11-03-30

<b>Dart Aerospace</b>	Ltd
-----------------------	-----

Dart Ae	rospace	Ltd								1 1
W/O:			wφ	RK ORDER CH	ANGES	•				
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·			******						
Part No	:	PAR #:	Fault Categ	ory:	NCF	R: Yes	No <b>DQA</b> :		Date: _	
	Re	esolution:	Disposition	•	QA:	N/C CId	osed:		Date: _	<u> </u>
NCR: ,	3		WORK ORDE	R NON-CONFO	RMANCE	(NCR	)			
DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip		Sign &	Verifica		Approval	Approval

NCR:		•	WORK ORI	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
					i i			
					:			
						Table		

## **Picklist Print**

Monday, March 28, 2011 11:41:55 AM

Work Order ID: 67587

Parent Item:

D3189-1

Parent Item Name: Chafing Shield



Start Date: 3/28/2011

Required Date: 3/31/2011

**Start Qty: 12.00** 

Loc Code

Required Qty: 12.00

Comments:

IPP B□05.08.22□No longer made in-house□KJ/JLM□

IPP Rev:C 06-03-24 Rolling Now made in House JLM

IPP Rev:D 07-04-16 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased	No			100	sf	2.0000	0.32	4.042105			,
										Sa	110-	3/29	

304/316 .020" Sheet

Loc Qty Location MAT20 2

107436

2

4.042

Page 1

# **Dart Aerospace Ltd**

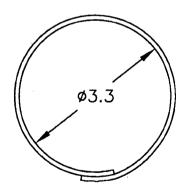
	-			1						
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date C	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•							
Part No	:	PAR #:	Fault Cate	egory:	_ NCR	: Yes N	lo DQA:	- 1	Date:	
	R	esolution:	Dispositio	on:	_ QA:	N/C Clos	sed:	·	Date:	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR)				
DATE	STEP	Description of NC			ion B	0:	Verificati	ion	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section (	С	Chief Eng	QC Inspector
	ļ									
	-									
					:					
	1	1	ı I		1		1		1	1



	DESIG	" P	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	Sh.
ı	CHECK	(ED #/	APPROVED //	DRAWING NO.	REV. B
-		-#	- N	D3189 SHEET 1	0F 2
	DATE			TITLE	SCALE
	07.0	1.05	· 	CHAFING SHIELD	1:2
	Α		03.05.08	NEW ISSUE	
	В		07.01.05	ADD -3	

RELEASED 07.03.27

11.25 -SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT 4.13 WITHOUT NOTICE WORK ORDER NO. 67587 pl 11-03-26 D3189-1 FLAT PATTERN R0.063 (TYP)



D3189-1 ROLLING DETAIL NOT TO SCALE

### D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

<b>Dart Aerospace L</b>
-------------------------

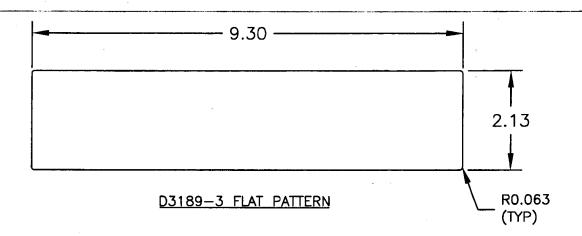
W/O:			W	<b>VORK ORDER</b>	CHANGES					
DATE	STEP	PRO	CEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									1 100 Wg	
		PAR #:	Fault Ca	tegory:	ļ r	ICR: Yes	No <b>DQ</b>	<b>A</b> :	Date:	
		Resolution:	Disposit	ion:	c	QA: N/C Closed:				Date:
NCR:		V	VORK OR	DER NON-CO	NFORMAN	CE (NCF	R)			
DATE	STEP	Description of NC	Corrective Active				Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action De	scription Eng	Sign 8 Date	Secti	Section C	Chief Eng	QC Inspector
			·							
						1				
									1	
		'								
	1						1			

<sup>\*</sup> H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

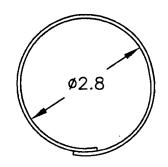


DESIGN P	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA	
CHECKED by	APPROVED	DRAWING NO.	REV. B
#	<b>—</b>	D3189	SHEET 2 OF 2
DATE		TITLE	SCALE
07.01.05		CHAFING SHIELD	1:2





ulo 67587



D3189-3 ROLLING DETAIL NOT TO SCALE

#### D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:			W	ORK ORDER	CHANGE	S					
DATE	STEP	PROC		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		•							1 Tod Wigi		
Part No:		PAR #:	_ Fault Cat	tegory:	NCR: Yes No DQA: Date:						
	R	esolution:	_ Disposit	ion:	QA: N/C Closed: Date:						
NCR:		W	ORK ORI	DER NON-CO	NFORMAN	NCE (NCR	)				
DATE	STEP	Description of NC Section A	Corrective Action			Section B		Verification	Approval	Approval	
			Initial Chief Eng	Action De	scription <sup>Eng</sup>	Sign & Date		ion C	Chief Eng	QC Inspector	
	}										
						3					
	1	1	1	1		I	i		1	1	

<sup>\*</sup>H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE